

Fig. 1

Fig. 2

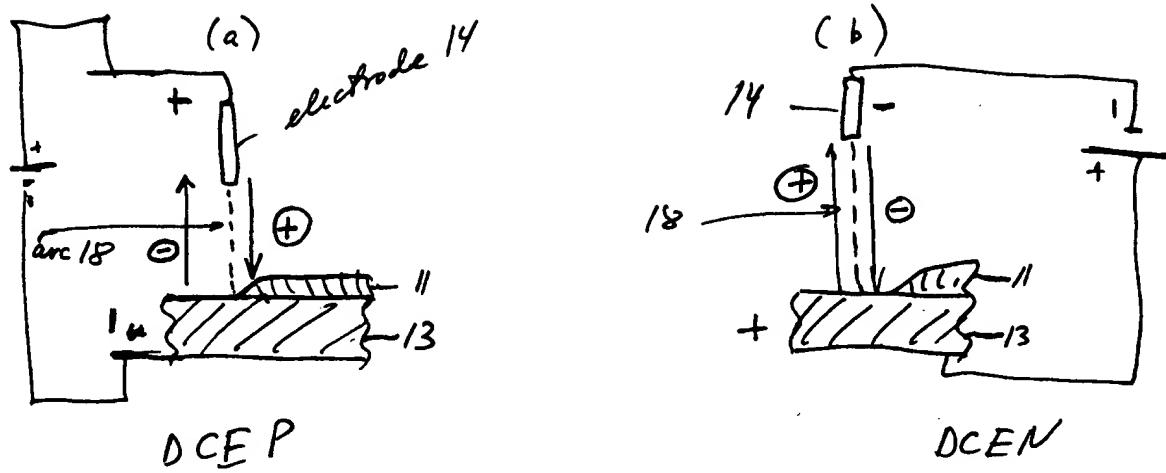


Fig. 3

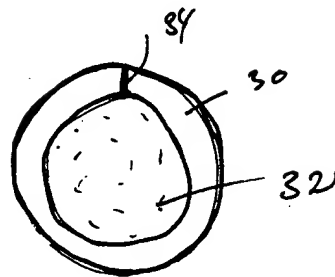
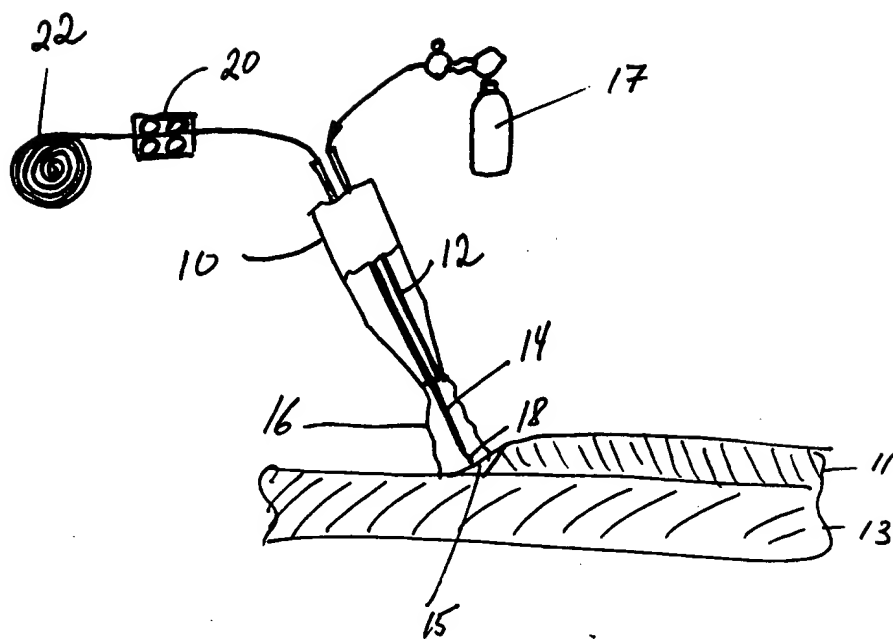


Fig. 4



Fillet size	sample id	weld par. wfs/V	DCEP travel, cm/min	sample id	weld par. wfs/V	DCEN travel, cm/min	INCREASE
0.125	A2	580/30	135	D2	620/27	185	37.0%
0.187	A3	620/30	120	D3	780/29	165	37.5% *
0.25	A4	620/29	100	D4	780/30	135	35.0% *
0.3125	A5	620/29	60	D5	780/30	75	25.0% *

\* note: the wire feeder was running at max 780 ipm, perhaps with more wfs this number could be higher

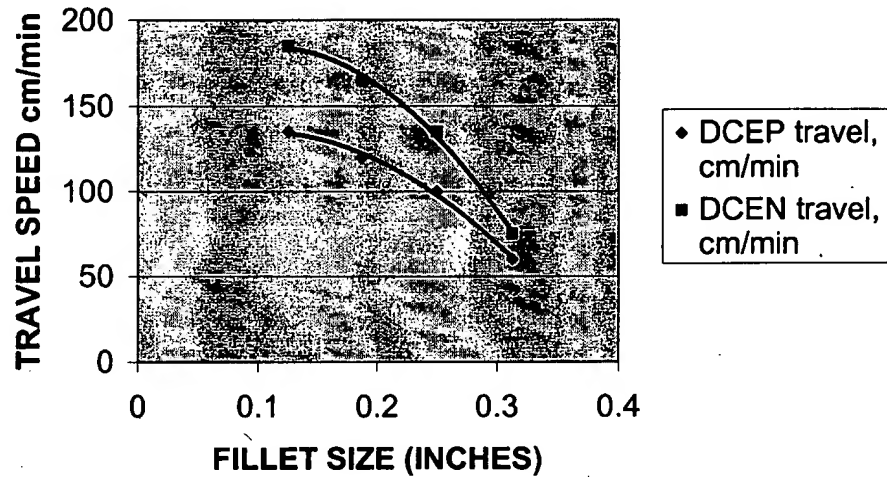


Fig. 5